

Date: Tuesday, 9/4/2007 11:29:52 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : EYEBALL ADAPTER
Job Number : 34404	
Estimate Number : 12237	
P.O. Number : <i>N/A</i>	Part Number : D34803
This Issue : 9/4/2007 S.O. No. <i>N/A</i>	Drawing Number : D3480 REV.B
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 32043	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 10/4/2007 Qty: 6 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : est rev. A 06.02.07 new issue EC	
Est. Rev B Now on Water jet 06.04.18 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S26GA	304/316 0.018 SHEET
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Comment: Qty.: 0.0662 sf(s)/Unit Total : 0.3969 sf(s)
 AISI 304/316 0.018 SHEET Batch: *M 105 490 IB 07-09-06*

2.0	WATER JET	FLOW WATER JET
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PROG B
DWG B

IB 07-09-06



(6)

Comment: FLOW WATER JET
 Cut as per dwg D3480

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



IB 07-09-06



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

En 07/09/06 (46) counter

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 1-Roll as per dwg D3480
 2-Spot weld as per dwg D3480
 3-Deburr

SMD 07/09/06 (6)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 7/10/17
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 9/4/2007 11:29:52 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: EYEBALL ADAPTER

Job Number: 34404

Part Number: D34803

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

~~QC~~ QC11

VISUAL WELDING INSPECTION

GA



Comment: VISUAL WELDING INSPECTION

SB 07/09/10

6

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/09/10

6

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB 07/09/10

6

9.0

QC21

FINAL INSPECTION/W/O RELEASE



6

Comment: FINAL INSPECTION/W/O RELEASE

DO 10/09/11

Job Completion



u 07/09/11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

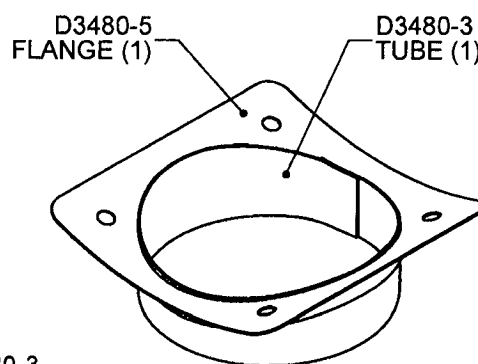
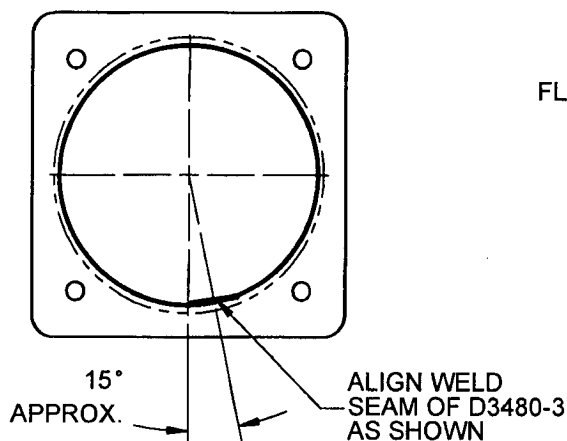
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

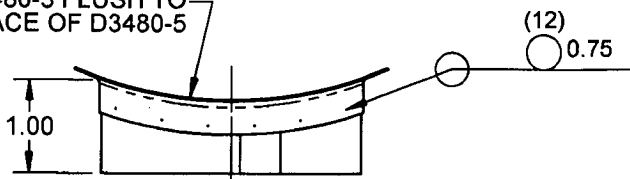
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CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D3480	REV. B SHEET 1 OF 6
DATE 06.08.29		TITLE EYEBALL ADAPTER	SCALE 1:2
A	06.02.06	NEW ISSUE	
B	06.08.29	D3480-3 0.50 was 0.40/D3480-3F 8.930 was 9.330	



SPOT WELD PARTS, THEN
CUT D3480-3 FLUSH TO
SURFACE OF D3480-5



D3480-041 EYEBALL INLET ADAPTER

NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N D3480-041 USING FINE POINT PERMANENT INK MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3480-041	EYEBALL INLET ADAPTER
1	D3480-3	TUBE
1	D3480-5	FLANGE

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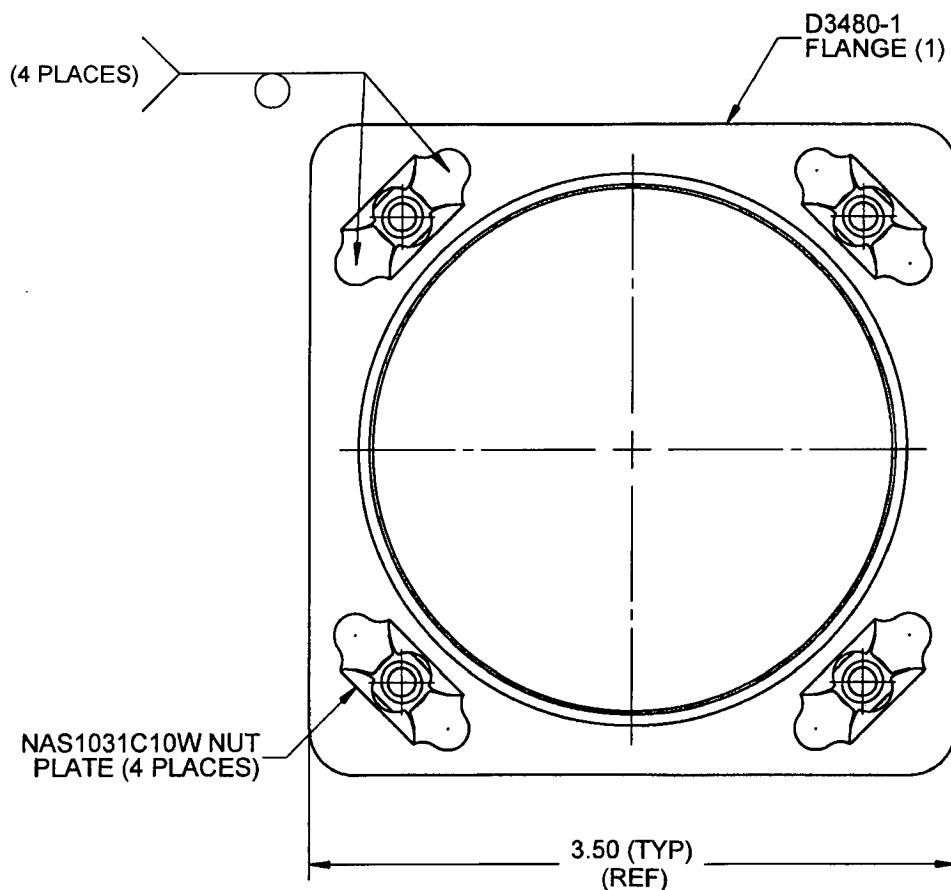
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DATE 06.08.29		TITLE EYEBALL ADAPTER	SHEET 2 OF 6 SCALE 1:1

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06.09.19 *[Signature]***D3480-043 EYEBALL ADAPTER**

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NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N D3480-043 USING FINE POINT PERMANENT INK MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

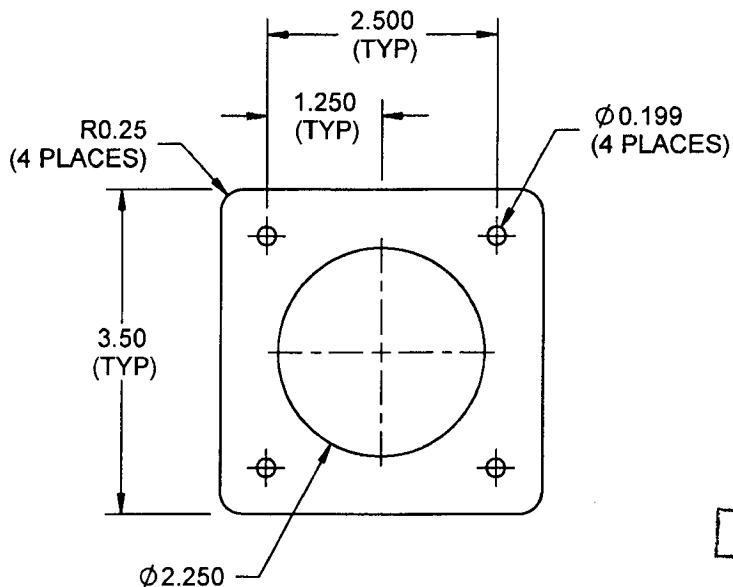
QTY -043	P/N	DESCRIPTION
X	D3480-043	EYEBALL ADAPTER
1	D3480-1	FLANGE
4	NAS1031C3W	NUTPLATE

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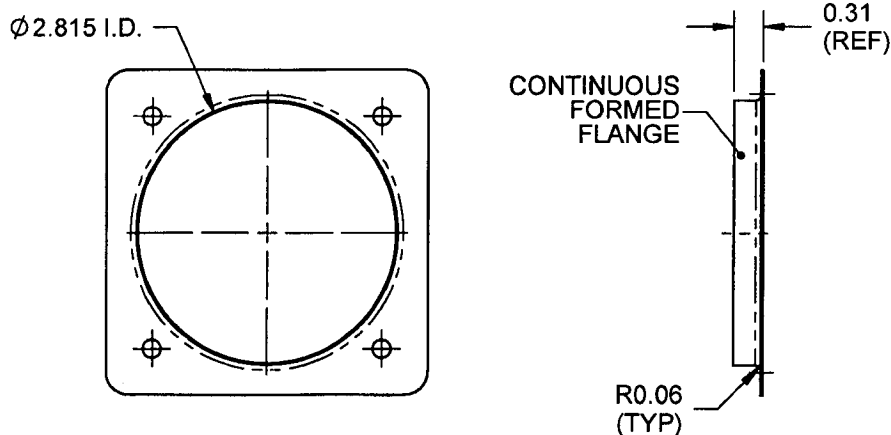


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DATE 06.08.29		TITLE EYEBALL ADAPTER	SCALE 1:2



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D3480-1F FLAT PATTERN



D3480-1 FLANGE (MAKE FROM D3480-1F)

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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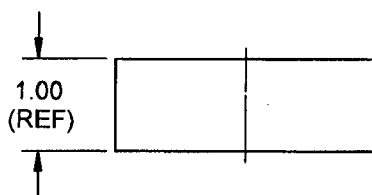
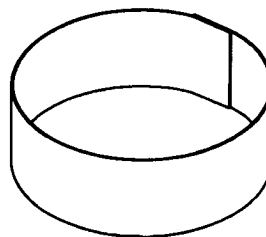
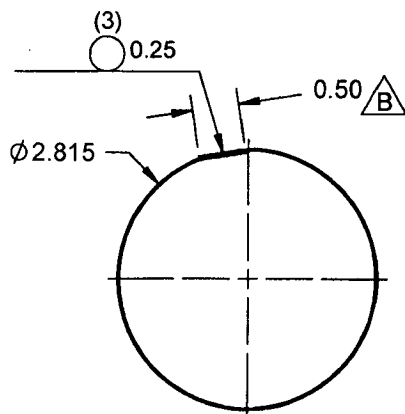
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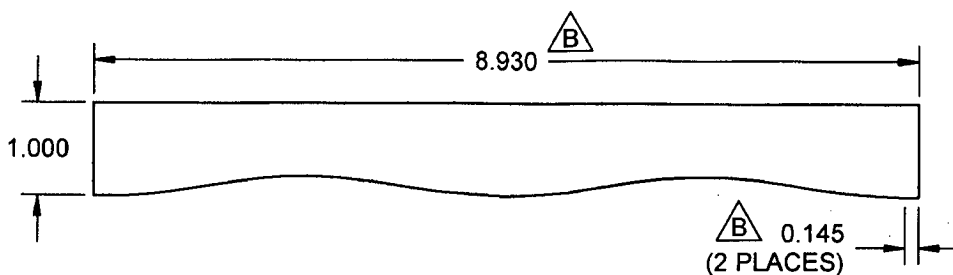
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DATE 06.08.29		TITLE EYEBALL ADAPTER	SHEET 4 OF 6
			SCALE 1:2



D3480-3 TUBE

RELEASED

06.09.19 *AB*



D3480-3F TUBE FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

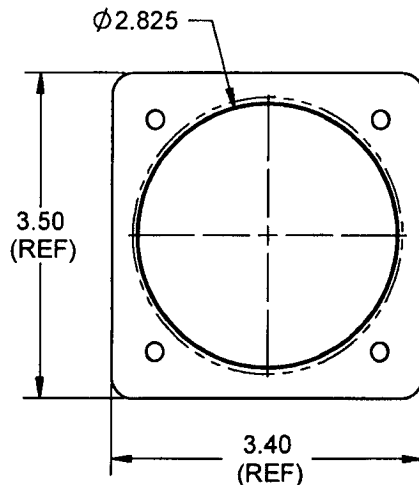
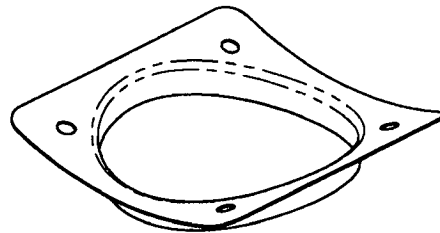
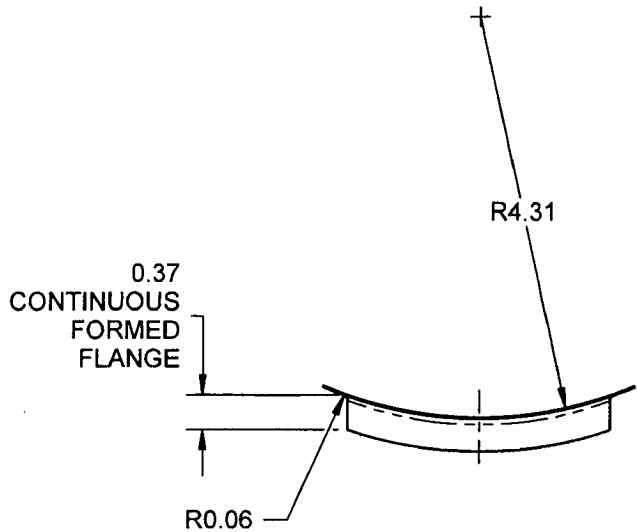
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DATE 06.08.29		TITLE EYEBALL ADAPTER	SCALE 1:2

**RELEASED**06.09.19 *H***D3480-5 EYEBALL ADAPTER FLANGE****NOTES:**

- 1) MATERIAL: MAKE FROM D3480-1F
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

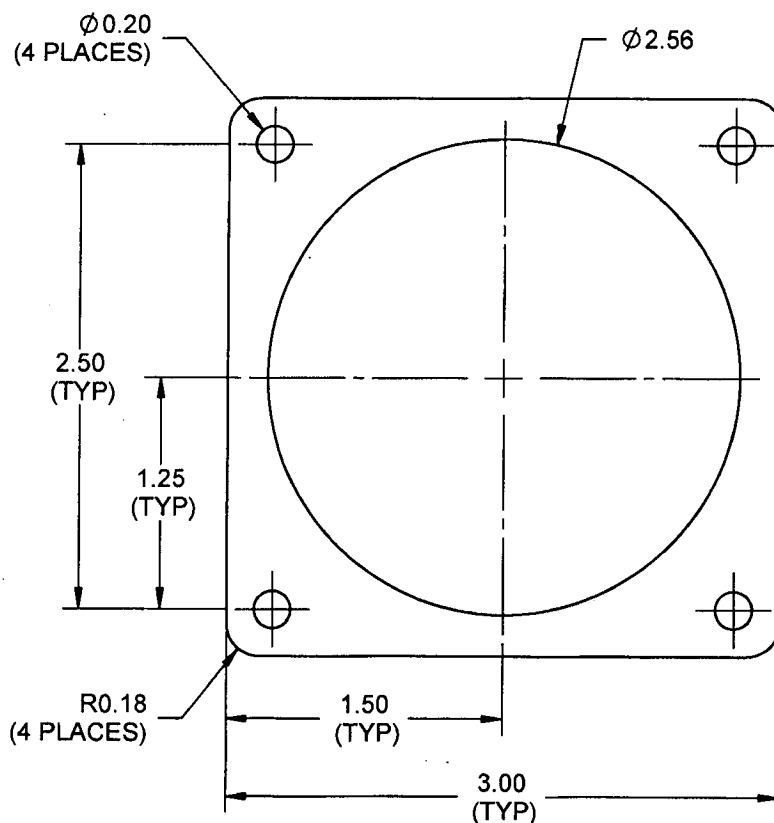
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DATE 06.08.29		TITLE EYEBALL ADAPTER	SCALE 1:1



RELEASED

06.09.19 *PH***D3480-7 GASKET****NOTES:**

- 1) MATERIAL: RED (OR GRAY) 60 DUROMETER HI-TEMPERATURE SILICONE SHEET, 0.125" THICK (REF. DART SPEC. M-SIL60-.125)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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SPOT WELD TEST RECORD
AMS-W-6858A
CLASS 'C'

TEST NO#: 9

EMPLOYEE: Manigault Depage

PART NUMBER: D 3480-3

JOB NUMBER: B 34404

MATERIAL TYPE: 304L

MATERIAL THICKNESS: .015

GROUP SPECIFICATION

- ☐ Group 1: Aluminum & magnesium
☐ Group 2: Iron; nickel; cobalt
☒ Group 3: Titanium

TEST RESULTS

	PASS	FAIL
VISUAL:	<u>✓</u>	
PENETRATION:	<u>✓</u>	
PULL STRENGTH:	<u>✓</u>	
		PSI Reading: _____

Qualified in accordance with standard AMS-W-6858A and QSI 004 (ref: 4.3)

DATE OF TEST COUPON: 07/29/10
QUALIFIER: QB